

Work Order ID 69759

Wednesday, May 18, 2011 1:01:12 PM



Page 1

Item ID: D3535-39	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearshoe					
Start Date: 5/18/2011	Start Qty: 16.00		Cust Item ID:		
Required Date: 5/23/2011	Req'd Qty: 16.00		Customer:		
Reference:					
Approvals: Process Plan:	Date: 11-05-10	Tooling:		Date:	
QC:	Date:	SPC (Y/N):		Date:	
			Run	Start	
				Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
304-040	1-Cut as per Dwg D3535 <input type="checkbox"/> Dwg Rev: B <input type="checkbox"/> Prog Rev: B <input type="checkbox"/> 2- Deburr if necessary								(13)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

B11-5-31

B11-5-31

(X13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 69759

Wednesday, May 18, 2011 1:01:12 PM



Page 2

Item ID: D3535-39

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 5/18/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Deburr if necessary ☐ Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. ☐ Identify as D3535-41 ☐ Form Joggle on brake using Jig DT8158 as per Dwg D3535

SB 11/06/06

(13)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SB 11/06/06

(14)

150

0.00



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

Powder Coating

START TIME:

☐ OVEN TEMPERATURE:

☐ FINISH TIME:

7:30

8:00

3200F

13x / M-11/06/06

M 115128

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Page 3

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Setup Start



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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				13	BR	11-6-6	
170 Packaging Packaging	Identify as per dwg & Stock Location: <i>FP-19</i> Memo	0.00 0.00				13	BR	11-6-6	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/6/7</i> <i>MF</i> <i>11-06-06</i>

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Picklist Print

Wednesday, May 18, 2011 1:01:18 PM

Page 1

Work Order ID: 69759



Parent Item: D3535-39



Parent Item Name: Wearshoe

Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

80.7000

0.951

16.01684



13-11-5-31

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

80.7

116623

0.2

117550

80.5

117558

13

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DART AEROSPACE LTD		Work Order:	69759
Description: Wearshoe		Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	✓		T B01	
32.775	+/-0.010	32.775	✓		T	
29.275	+/-0.010	29.275	✓		T	
25.775	+/-0.010	25.775	✓		T	
23.250	+/-0.010	23.250	✓		T	
19.750	+/-0.010	19.750	✓		T	
17.750	+/-0.010	17.750	✓		T	
14.250	+/-0.010	14.250	✓		T	
9.500	+/-0.010	9.500	✓		T	
4.750	+/-0.010	4.750	✓		T	
2.000	+/-0.010	2.000	✓		✓ B02	
5.00	+/-0.030	5.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
28.00	+/-0.030	28.00	✓		T	
Ø0.188	+0.005/-0.001	.191	✓		V	
1.885	+/-0.010	1.888	✓		V	
0.300	+/-0.010	.302	✓		V	
0.300	+/-0.010	.303	✓		V	
0.038	+/-0.010	.035	✓		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-5-31	Date:	11/06/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

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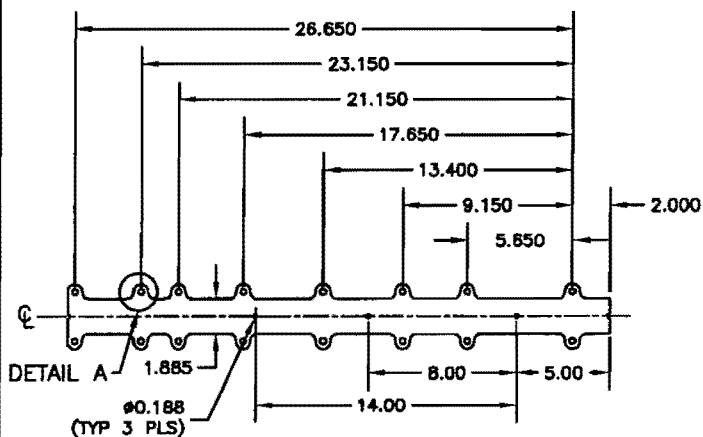
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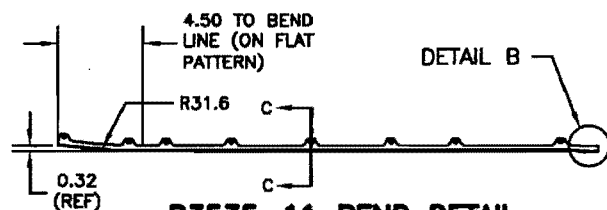
DART

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07.04.24

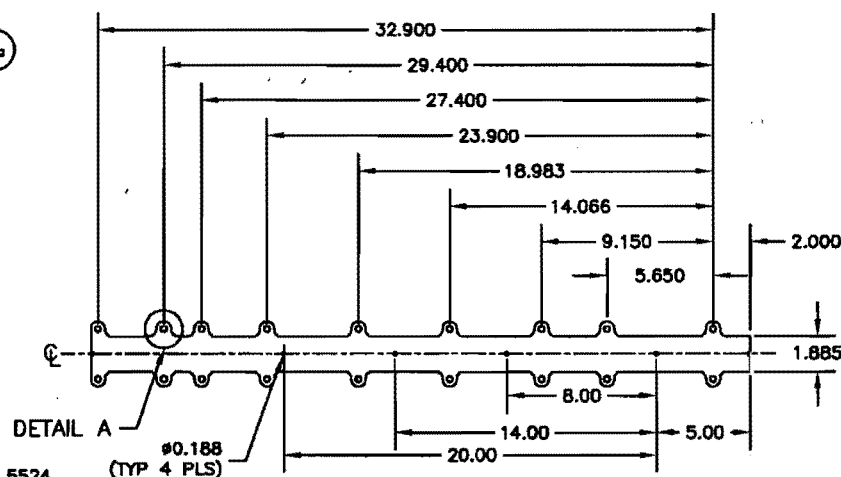
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69759
2/11-05-18



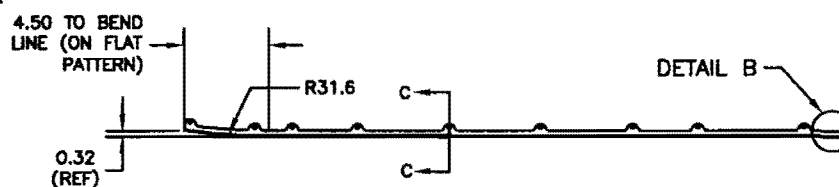
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC
		SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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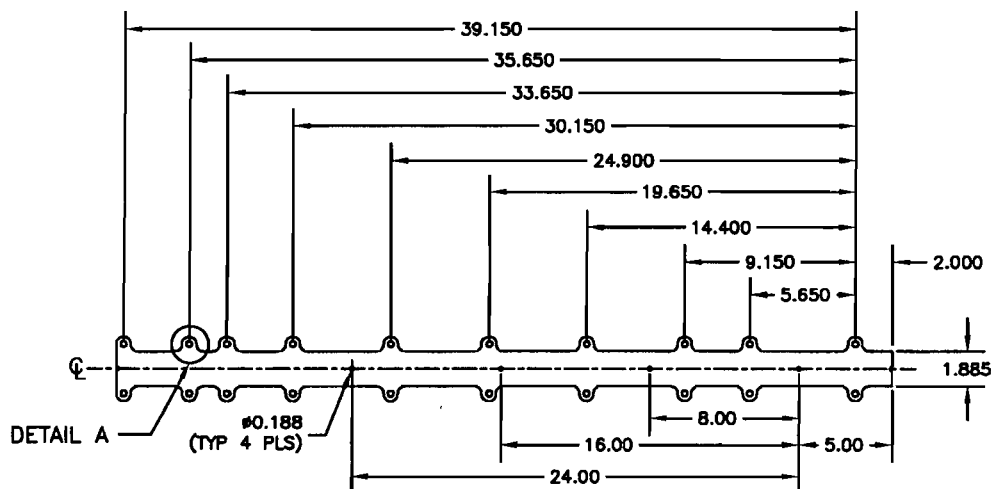
NOTE: Date & initial all entries

DART

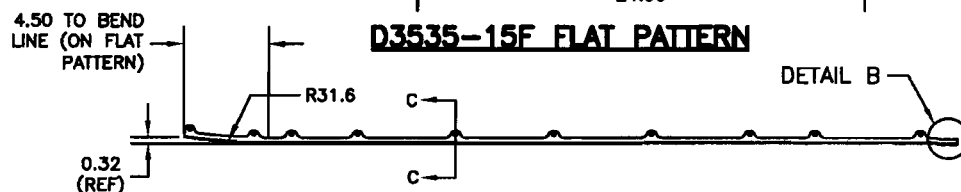
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07.04.24

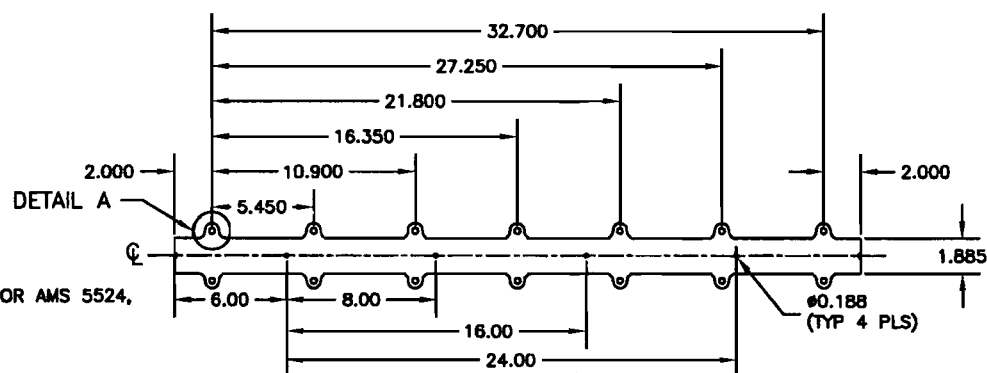
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REVISION
07.04.17	WEARSHOE	SHEET 2 OF 7
		SCALE
		1:10



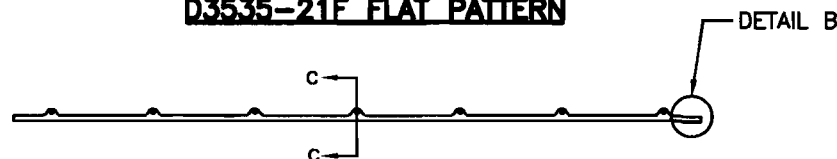
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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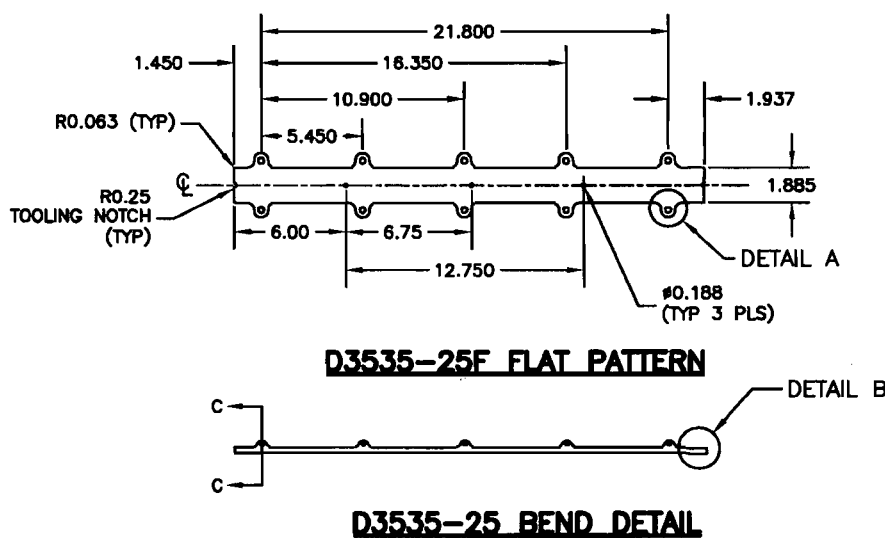
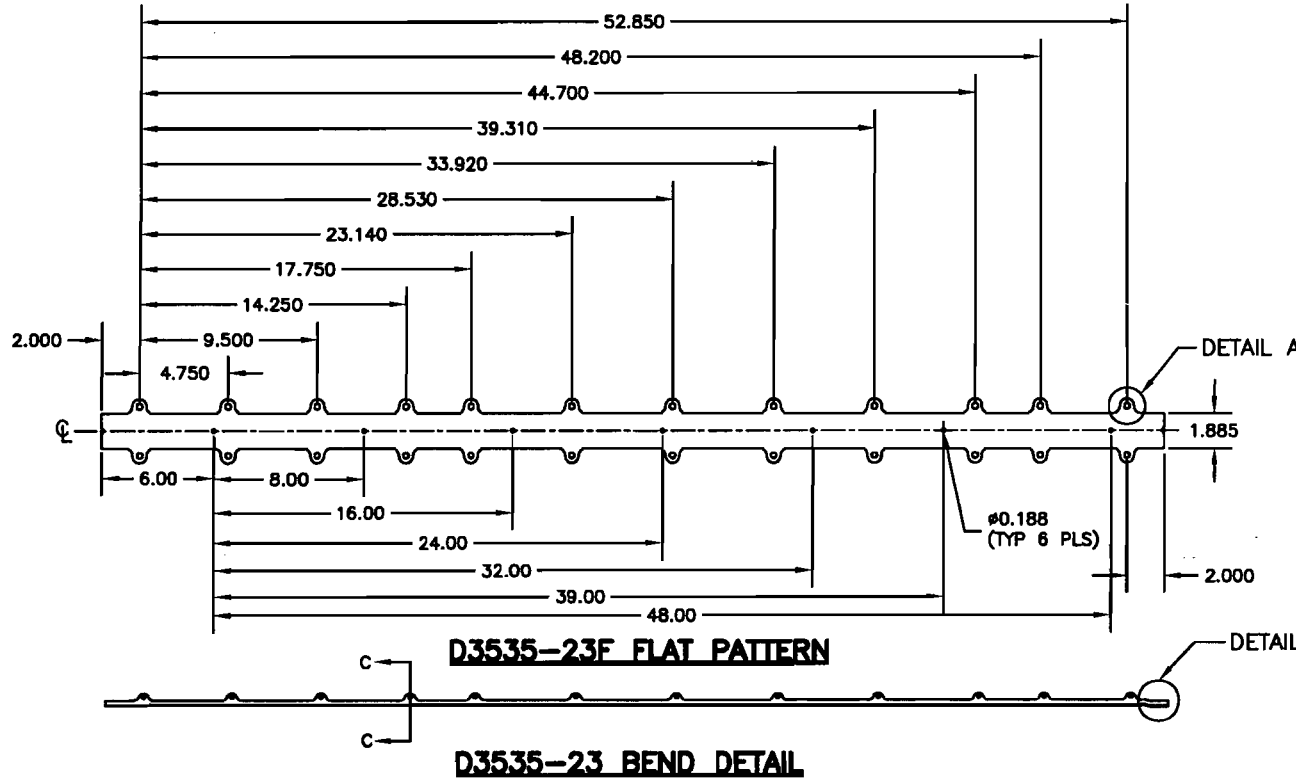
NOTE: Date & initial all entries



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07.04.24

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
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CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 3 OF 7
		SCALE
		1:10



- NOTES**
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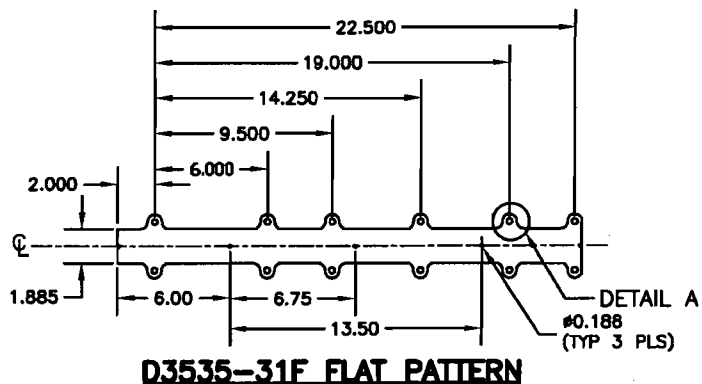
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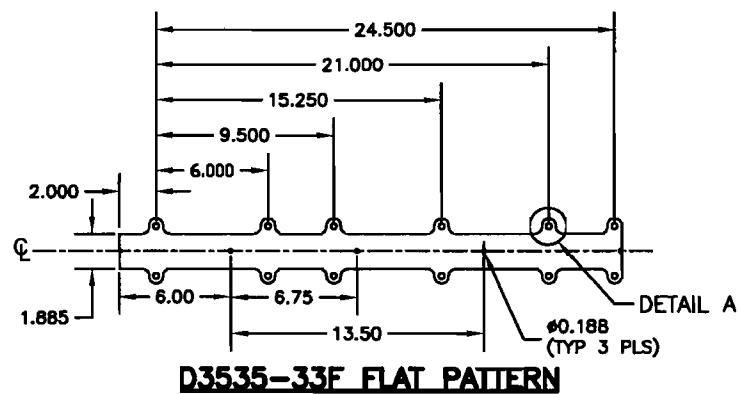
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CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

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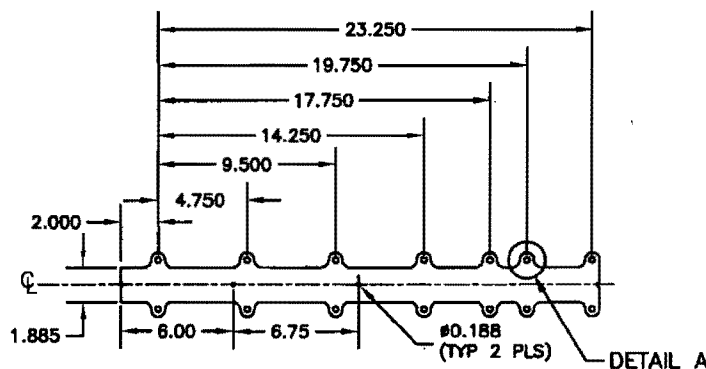
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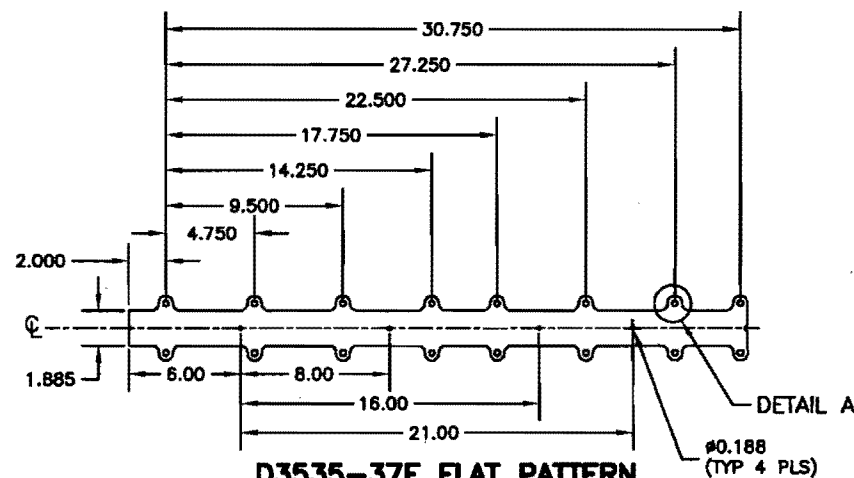
also 19759



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 5 OF 7
	SCALE 1:10	

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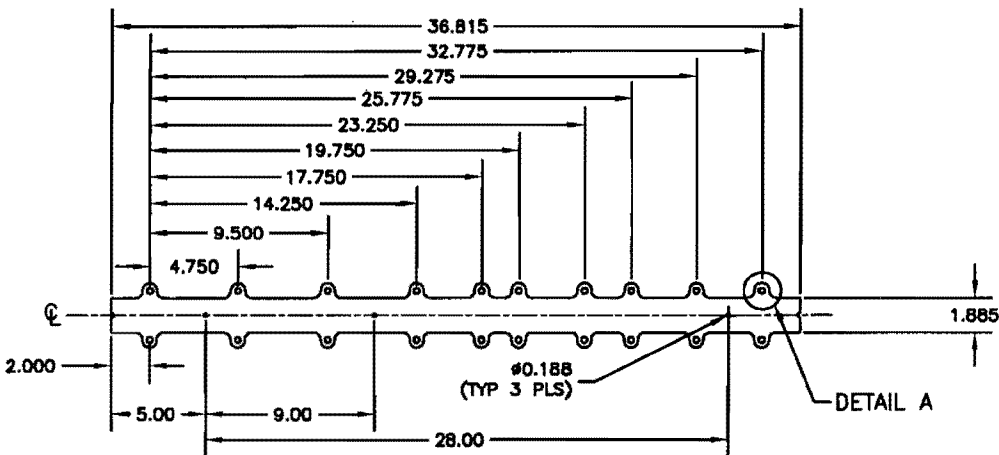
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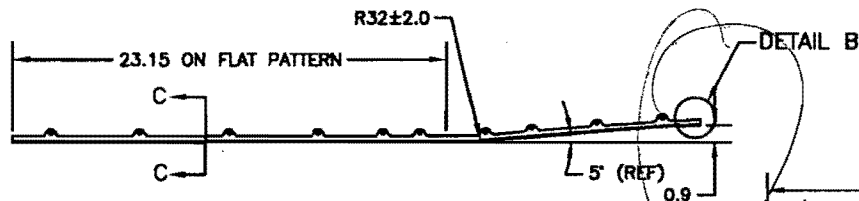
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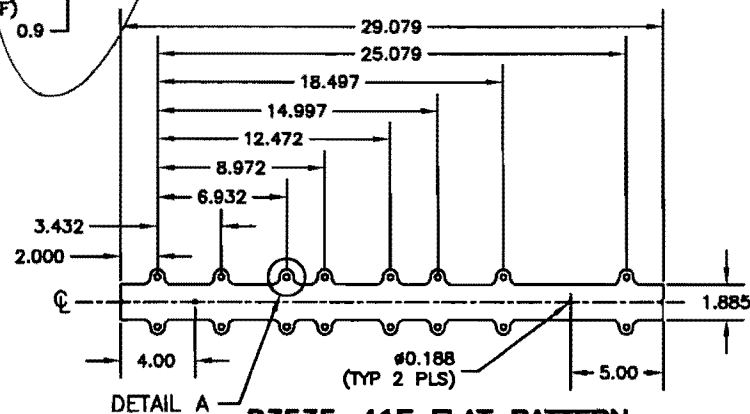
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07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE 1:10



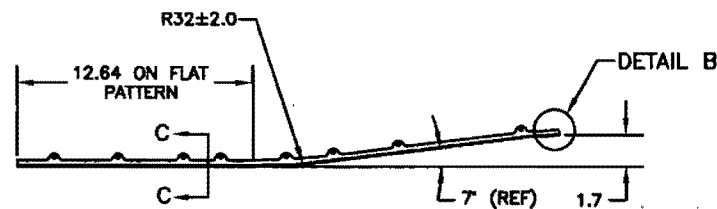
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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